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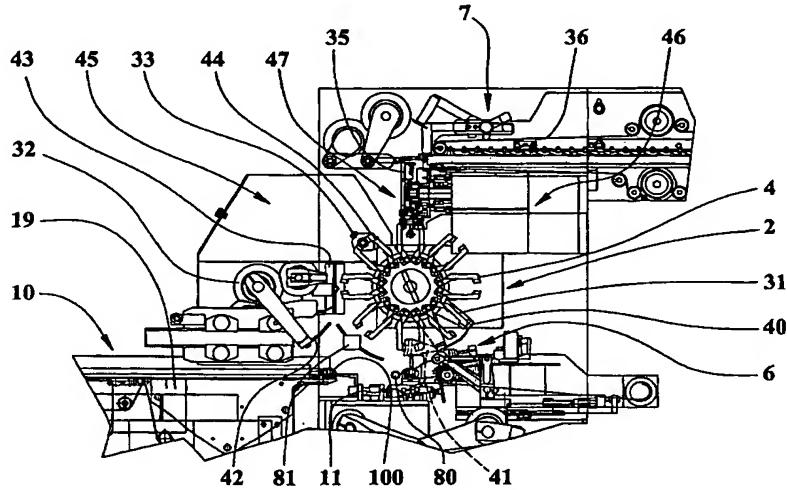
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(54) Title: WRAPPING MACHINE



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(57) Abstract: A wrapping machine for wrapping chocolates and similar products (100) with a wrapping material (101), includes an unwinding and cutting group (6) and a feeding group (10), fit for feeding an elevator group (5) respectively with a portion of the wrapping material (101) and a respective product (100). Said wrapping material portion (101) and respective product (100), are provided from said elevator group (5) to a wrapping head (2) to mate a folding group (3) wrapping the product before the transfer of the wrapped product to an outlet group (7). The wrapping head (2) has at least eight gripper means (4) for the product (100) associated to the wrapping material portion (101). The folding group (3) includes a plurality of folding modules, at least first (31), second (32) and third (33). The folding group (3) includes at least three seats first (45), second (46) and third (47) fixed around the wrapping head (2) for housing alternatively and removably at least one of the folding modules (31,32,33). One or more folding modules (31, 32, 33) are independently operated to carry out different wrapping styles of the wrapping material (101).

WRAPPING MACHINE**TECHNICAL FIELD**

5 The present invention relates to automatic packaging machines, and particularly the invention refers to a wrapping machine for wrapping chocolates, candies, sweets and similar products having different shape with different wrapping style.

BACKGROUND ART

10 The known wrapping machines are provided with mobile or fixed folding members, which allow to carry out a single predefined wrapping style. It is possible to carry out a different wrapper, still belonging to the same wrapper typology, only by suitably replacing and/or modifying the folding members. Usually, said known machines do not allow to carry out
15 wrappers belonging to other wrapping styles. Typically a machine fit for carry out double twist wrappers can carry out, after changes, a single twist wrapper, but it is not able to carry out an envelope portfolio or a bunch wrapper.

20 The main drawback of said known machines consists in the production rigidity that is in the restricted selection of wrapping styles, which can be carried out.

Other drawback consists in that the replacement operations of the folding members, for adjusting the machine for a different wrapping style, are difficult and require long machine stops, with consequent interruption of production and increase of costs.

25 There are modular wrapping machines that allow realizing several wrapping styles by assembling suitable folding modules to the basic structure of the machine.

30 The main drawback of said machines consists in that such flexibility is possible only during the production phase of the machine since the modules, once assembled to the machine, can not be disassembled and replaced in reasonable times, precluding the flexibility and versatility of the machine, once the latter is working at the production plant.

35 Other drawback of the known wrapping machines consists in that it is impossible to modify or change the product outlet flow, according to the specific production demands.

It is known that in the wrapping machines for rectangular chocolates and similar products with traditional wrapping styles, the wrapping material must move parallelly to the product short side, which for stability demands is moved along a direction parallel to the product long side. For this reason said machines have a product feeding group, usually a belt or belts in cascade, 5 perpendicular to the wrapping material flow on the machine and thus to the machine main axis.

The main drawback of such machines is the position of the feeding group, which makes more difficult the access to the machine maintenance points positioned at the opposite sides with respect to said feeding group and preclude an operator to control at the same time two wrapping 10 machines, parallelly positioned.

There are also known wrapping machines for chocolates or similar products having a flat base, provided with of feeding groups including one or more storage belt, parallelly positioned with respect to the wrapping material flow of the machine. In this case, the aligned products in 15 mutual contact, due to the push of the queue, are moved to the picking zone, in which a pusher insert, one by one, the products into a feeding disk or into a positioning wheel, in order to rotate of 90° the products and to position them with the correct orientation at the following working station.

20 The main drawback of said feeding groups consists in that for high motion speeds the products tend to slip on the storage belt, causing an idle turn of the wrapping machine with consequent production and efficiency decrease.

Other drawback consists in that the stresses exerted on the products by the pusher and by the 25 feeding disk, in order to position the product in the following station, may cause damages of products, with possible detachments of splinters and portions thereof, which may dirt and/or obstruct the machine members.

DISCLOSURE OF THE INVENTION

30 Object of the present invention is to propose a wrapping machine for wrapping chocolates or similar, which is fit to carry out completely different wrapping styles, allowing to pass in an easy and quick way from a wrapping style to others, without changes or difficult adjustment operations of the folding members.

Other object of the present invention is to propose a machine, which can be integrated with a plurality of different feeding groups of known type, different groups according to the product to be wrapped, to their speed and to the wrapping style to perform on the product.

- 5 Further object is to propose a machine, which can have different configurations of the product outlet, in such way to satisfy the different plant demands of final user.

Other object of the present invention is to propose a wrapping machine provided with a feeding group which can operate at very high speeds, guaranteeing both a regular and reliable operation, 10 without blockages, jams and product feeding lacks, and a delicate handling and/or moving of the product preserving it from damages.

The above-mentioned objects are achieved according to the claim contents.

15 BRIEF DESCRIPTION OF THE DRAWINGS

The characteristics of the present invention are underlined in the following with particular reference to the attached drawings, in which:

- figure 1 shows a front schematic view of the wrapping machine of the present invention;
- 20 - figure 2 shows a plan partial view of figure 1 machine;
- figure 3 shows an enlarged partial section front view of figure 1 machine;
- figure 4 shows an enlarged partial front view of a feeding group of figure 1 machine;
- figure 5 shows a plan view of the feeding group of figure 4;
- figure 6 shows a partial section view according to the plan VI-VI of figure 4;
- 25 - figure 7 shows a schematic perspective partial view of a variant of figure 1 machine, having a feeding group with storage belt, pusher and filling disk, in association with products in different wrapping steps;
- figure 8 shows a schematic perspective partial view of another variant of figure 1 machine having a feeding group with hopper and filling disk in association with products in different 30 wrapping steps;
- figure 9 shows a schematic perspective partial view of a further variant of figure 1 machine characterized by a feeding group with slot belt in association with products in different wrapping steps.

35 BEST MODE OF CARRYING OUT THE INVENTION

With reference to figures 1 to 6, numeral 1 indicates a wrapping machine to enfold chocolates and similar products 100 by a wrapping material 101, substantially constituted by an unwinding and cutting group 6 of the wrapping material 101 and a feeding group 10 of the product 100.

5 The unwinding and cutting group 6 and the feeding group 10, feed an elevator group 5 respectively with a portion of wrapping material 101 and a respective product 100. The elevator group 5 provides the product 100, associated with the wrapping material 101, to a wrapping head 2 for mating a folding group 3 and for transferring the wrapped product 100 to an outlet group 7.

10

The wrapping head 2, rotating on a horizontal axis, has eight gripper means 4 radially and angularly equidistant for gripping the product 100 and the wrapping material 101.

15 The folding group 3 is constituted by a plurality of folding modules, first 31, second 32 and third 33, which are positioned around the wrapping head 2 and are fit for folding borders of wrapping material 101 around the product 100 according to different wrapping styles.

20 The machine includes three seats first 45, second 46 and third 47, which are fixed around the wrapping head 2 in different positions, approximately in correspondence of sequential positions of the gripper means 4 of the wrapping head 2 in the stop steps. The seats are fit for alternatively and removably housing one of the folding modules, usually the third module 33, according to the required configuration of the machine 1.

25 The first folding module 31 includes a first folder means 40, of known type, which is mobile along a tangential direction with respect to the wrapping head 2, in order to fold a lower border of a wrapping material portion 101, in case a double twist or fancy wrapping style has to be carried out.

30 In alternative, the first folding module 31 includes second folder means 41, of known type, mutually facing and oscillating in a tangential direction with respect to the wrapping head 2 in order to fold side borders of wrapping material portion 101, pre-shaped by the passage through fixed folders during the product elevation, and to carry out an envelope portfolio wrapping style.

35 The second folding module 32 include folder means second 42 and third 43, of known type,

constituted by two couples of opposing folders, fit to carry out orthogonal and opposed folding of borders of a wrapping material portion 101 with envelope portfolio or fancy or bunch style.

The third folding module 33 includes a couple closing fingers 44 which realize the final double
5 twist closing of a wrapping material 101.

The machine further includes first fixed folder means 80 which are interposed between the elevator group 5 and the wrapping head 2 and which, during the motion of respective product 100 by means of elevator group 5, provide to realize respective folding of wrapping material 101. Particularly, the first fixed folder means 80, according to their geometry and conformation, execute a "H" shaped folding for an "envelope portfolio" wrapping style, or an upturned "U" shaped folding for a "double twist" wrapping style or a "hood" folding for a "bunch" wrapping style.
10
15

The machine 1 also include second fixed folder means 81 positioned close to the wrapping head 2 and fit to carry out suitable folding of wrapping material 101 on the product 100, during the transfer thereof from the first folding module 31 to the following modules 32, 33.
20

If the machine must carry out double twist or fancy wrapping styles for ovoid or spherical products, the second folder means execute the tubular closing of wrapping material 101, by folding the corresponding side edge.
25

It is important to underline that using different modules, separately or in combination, the machine can carry out wrappers 101 having very different wrapping styles. The time needed for the size change over, or rather the replacement of mobile and fixed folders, shaped according to the dimensions and/or type of product 100, is very easy and fast.
30

The first fixing seat 45 is approximately adjacent to the second folding module 32, while the second seat 46 is in position almost symmetrical to the first seat 45, with respect to a vertical plan passing through the rotating axis of wrapping head 2. The third seat 47 is interposed between the seats first 45 and second 46 and is approximately aligned to the vertical plan passing through the rotating axis of wrapping head 2.
35

By fixing the third folding module 33 to the first seat 45, the machine 1 can have an outlet group 7 of the product including removal means 35, of known type, which take each product

100 wrapped by the wrapping head 2 and transfer it to transport means 36, consisting for instance of a belt of known type, in order to orderly move outwards the products 100, according to a motion direction which is parallel to the feeding direction of products 100 in the feeding group 10 and which has the same sense.

5

In case the outlet group 7 includes chute means 38, for the bulk exit of products 100, the third folding station 33 can be connected to the second seat 46 or to the third seat 47.

Particularly, by positioning the third folding module 33 at the third seat 47, it is possible having
10 a double outlet group 7, constituted by removal 35 and transport 36 means, for products having "envelope portfolio", "fancy", "bunch" wrapping styles, and by following chute means 38 for double twist products.

If the removal means 35 and transport means 36 are not required but only the chute means 38
15 are requested, the third folding module 33 is fixed to the second seat 46.

The elevator group 5 includes articulated quadrilaterals 51, 52 of known type, connected to respective motorized cams and fit for moving a counter-elevator 50 and an elevator 53. The latter has side rests 59 for supporting side borders of wrapping material 101 and for avoiding
20 that said borders can be bent because of the air resistance, while raising the product 100.

In the preferred embodiment, the machine 1 includes a feeding group 10 of product 100 substantially constituted by a first belt means 13, a second belt means 14, a third belt means 16 and a positioning wheel 9.

25

The first belt means 13 has a continuous advance motion and supports and moves a plurality of products 100, aligned by a preceding alignment group, known and not shown, and arranged in a single line at mutual contact. The second belt means 14, which is aligned downstream the first belt means 13, has an alternate advance motion, in other words a periodical intermittent motion,
30 and is associated with holding means 15 of product 100, which operate on the portion of said second belt means 14 on which the products 100 are positioned.

The third belt means 16, which is aligned and upstream to the first belt means 13, has a continuous advance motion, with a translation speed greater than the speed of first belt means
35 13 and realizes the product store.

The holding means 15 are constituted essentially by an air suction means 17 connected through a duct means 19 to at least an opening 18 carried out in the second belt means 14, in order to hold and to constrain through suction the products 100 to the second belt means 14.

- 5 The suction means 17 consists of a vacuum pomp or a suction fan and the opening 18 may consist of a longitudinal slot, carried out by a couple of parallel and transversally spaced apart conveyor belts 22, which constitute the second belt means 14.

In alternative, the opening 18 may consist of a plurality of through holes carried out in the
10 second belt means 14.

The duct means 19 have, for instance, an elongated delta shape, and are provide with a suction mouth 23, which has an elongated shape and is in flow communication with the opening 18.
15 The suction mouth 23 is connected to the suction means 17, by means of an inner duct having divergent shape starting from said suction mouth 23 up to the connection with said suction means 17.

The feeding group 10 includes two first sensor means 20 of minimum and maximum load, fit to sense the presence of products 100 on the first belt means 13 and particularly to measure the
20 respectively the minimum and maximum dimension of the storage queue of products 100 on said belt, in order to reduce or to increase the speed of the machine of wrapping machine and/or of the upstream product flow.

There are furthermore second sensor means 25, positioned close to the portion of second belt
25 means 14 adjacent to the positioning wheel 9 and fit to sense the presence and the correct position of product 100 and consequently fit to define the operational steps between second belt means 14 and wheel 9.

The sensor means 20, 25 are of known type, such as optical type, for instance photocells or
30 optical fibers, or inductive type.

The second belt means 14 is powered by an electric motor 21 of Brushless type, position, speed and acceleration controlled, in such a way to move according to predefined and programmable motion laws, while the belt means first 13 and third 16 are rotated by a ratio-motor 24.

The positioning wheel 9, rotating on a vertical axis and facing the second belt means 14 downstream the holding means 15, has four pliers means 11 angularly and equally spaced apart fit for grasping the product 100 from the second belt means 14. The pliers means 11 are positioned at 90° one with respect to the other and fixed to the wheel 9 with an orientation 5 almost tangential to a geometric circumference inscribed in the positioning wheel 9 and concentric to the latter.

The positioning wheel 9 is substantially constituted by a first column 61, fixed to the machine 1 and rotatably supporting a second column 62 and a third column 63, coaxial thereto and 10 independently rotating with respect to a vertical axis.

Each pliers means 11 is fixed, through a support plate 68, to the third column 63 and includes a couple of mobile tines 12, symmetrically rotating between a closing condition C, in which said tines 12 are at their minimum distance for grasping a product 100, to an opening condition D, in 15 which they are at the maximum distance for releasing said product 100.

The opening and the closing of mobile tines 12 of each pliers means 11 is made through transmission means 65, connected to control means 64 of the second column 62 and moved by these last ones, by virtue of the partial alternate rotation of said second column 62.

20 Each transmission means 65 is essentially constituted by a pivot 67, which is slidably supported by the third column 63 and connected to the mobile tines 12 of the respective pliers means 11 through a pinion-rack connection. Furthermore the pivot 67 is slidably engaged, through sliding rolls 66, to a cam profile of control means 64.

25 The partial rotation of the cam profile causes the rising or descending translation of pivots 67 and, consequently respectively, the opening or closing rotation of mobile tines 12 of pliers means 11.

30 The wrapping machine is entirely controlled by calculation and control electronic means fit to control the phase relations between the feeding group 10, the sensor means 20, 25, the elevator group 5, the unwinding and cutting group 6, the wrapping head 2, the folding group 3 and the outlet group 7.

35 The operation of the wrapping machine 1 object of the present invention provides that the

folding modules 31, 32, 33 are independently activated in order to have different operational combinations for carrying out respective wrapping styles of wrapping material portion 101. For instance, by driving the folding modules, first 31 and second 32, in association with a fixed folder which operates, during the elevation stroke of the elevator, it is possible to carry out an envelope portfolio wrapping style, while driving the first folding module 31, having a first mobile folder 40, and driving the third folding module 33, it is possible to carry out a double twist wrapping material 101.

By positioning the fourth folding module 33, which can be connected to the first seat 45 or to the second seat 46, it is possible providing in different positions the wrapped product 100 to the outlet group 7.

The operation of feeding group 10 provides that the belt means third 16 and first 13 moves with uniform and continuous rectilinear motion the products 100 at different and decreasing speeds such to guarantee a storage queue of the products 100, controlled by minimum and maximum load sensor means 20, sufficient to feed without discontinuity the following the second belt means 14. The latter moves according to an alternate motion law, having a stroke equal to the product length to be moved and with a speed varying from a minimum value equal to zero to a maximum value, which is function of the machine cycle.

In the picking condition A of second belt means 14, while a product 100 is transferred from the first belt means 13 to the second belt means 14, another product 100, in a transfer condition T, is grasped by pliers 11 of the positioning wheel 9. By moving the second belt means 14 it is possible to progressively move the products 100 toward the positioning wheel 9. The gradual acceleration and deceleration of said belt means respectively at the start and at the end of the motion, allows to avoid the product slipping on said belt means and it allows, by virtue also of the particular layout of the pliers means 11 on the positioning wheel 2, the rotation of product 100, grasped by the pliers means 11, without interference with the following coming product.

In the moving conditions M of second belt means 14, in which the products are moved by the latter, the holding means 15 maintain each product 100 fixed to the belt means 14, cooperating in avoiding slipping phenomenon that could create gaps between the products, which can not be filled anymore, or even collisions between the products.

The second belt means 14 is moved by an alternate motion and with motion law of

asymmetrical cycloidal type, with asymmetry ratio of 1,5, that is with a duration of the acceleration phase equal to $\frac{3}{4}$ of the whole cycle and a deceleration phase equal to $\frac{1}{4}$ of the cycle. Such law guarantees a smooth and slow moving of products 100 on the belt, to reduce the risks of possible slipping of products.

5

During the operation of the machine, the positioning wheel 9 takes the product 100 from the second belt means 14 and moves it with alternated circular motion from the transfer condition T to a release condition R, in which the machine is motionless and the related pliers means 11 is opened for releasing the product 100 to the elevator group 5.

10

A variant of the wrapping machine 1 object of the present invention includes an outlet group 7, shown with dashed lines in figure 1, in which the wrapped products 100 are moved according to a motion direction, which is parallel to the feeding direction of products in the feeding group 10, but with opposite sense.

15

Another variant of the machine 1, schematically shown in figure 7, includes a feeding group 10 constituted by a storage belt 71, pusher means 72 and a feeding disk 73. The belt 71 has an alternate advance motion and transfers the products 100, aligned by a preceding storing system, known and not shown, to pusher means 72, which move each product 100 from said belt 71 to 20 the disk 73. The latter has a plurality of slots, shaped for housing the products 100, and it rotates on a vertical axis to transport the products to the elevator group 5. Typically this type of feeding group is used in case of chocolates or the like, having a flat base.

The machine further has an outlet group 7, essentially constituted by a chute 38 for bulk 25 collecting of products 100.

A further variant of the machine, schematically and partially shown in figure 8, includes a feeding group 10, constituted by a storage hopper 75 of products 100, which feeds a centrifugal filling disk 76, rotating on a vertical axis. The filling disk 76 has shaped seats 60 for 30 accommodating the products 100 and for transporting them to the elevator group 5. Typically, this type of feeding group is used in case of chocolates or the like having spherical or ovoidal shape.

The shown variant has an outlet group 7, in which the products 100 wrapped are moved 35 according to a motion direction which is parallel to the unwinding direction of wrapping

material 101, with respect to which the products have concordant sense. In such outlet group, each product 100 wrapped is taken by the wrapping head 2 and transferred to transport and rolling means 36, of known type, which complete wrapper with "fancy" style.

- 5 The figure 9 shows another variant of the machine, in which the feeding group 10 includes a slot belt 77 having counter-dies 78 for accommodating respective products 100 and their transfer to the elevator group 5. The products 100 are picked from moulding dies through suitable devices of "pick-and-place" type, known and not shown, and transferred on the belt 77.
- 10 It is provided a further variant of the machine, not shown, in which the feeding group 10 is of combined type or rather it includes a storage belt 71 with pusher means 72 and feeding disk 73, to process products with flat base and a hopper 75 with centrifugal filling disk 76, in case of spherical or ovoidal products.
- 15 Such type of combined feeding group allows moving products 100 having any shape, with flat base or sferical/ovoidal.

The main advantage of the present invention is to provide a wrapping machine for wrapping chocolates, candies or similar products, which is fit to carry out completely different wrapping styles, allowing easy and quick size change over operations for adjusting the machine for different wrapping styles.

Other advantage of the present invention is to provide a machine, which can be integrated with a plurality of different feeding groups of known type, according to the product to be wrapped, to the required speed and to the wrapping style.

Further advantage is to provide a machine, which can have different configurations of the product outlet, in such way to satisfy the demands of final user.

30 Other advantage is to provide a wrapping machine with a feeding group, which can operate at very high speeds, with a regular and reliable operation, without blockages, jams and product feeding lacks, and having a delicate handling and moving thereof, preserving it from damages.

CLAIMS

- 1) Wrapping machine for wrapping chocolates and similar products (100) with a wrapping material (101), including an unwinding and cutting group (6) and a feeding group (10) fit to feed a elevator group (5) respectively with a portion of wrapping material (101) and a respective product (100) which are provided associated from said elevator group (5) to a wrapping head (2) to mate a folding group (3) and to be transferred to an outlet group (7) of the wrapped product (100); said machine (1) being characterized in that:
 - the wrapping head (2) has radially and angularly equidistant at least eight gripper means (4) for the product (100) associated to the wrapping material portion (101);
 - the folding group (3) includes a plurality of folding modules, at least first (31), second (32) and third (33), positioned around the wrapping head (2) and fit to fold the wrapping material portion (101) around the product (100);
 - the folding group (3) includes at least three seats first (45), second (46) and third (47) fixed around the wrapping head (2) for housing alternatively and removably at least one of the folding modules (31, 32, 33);one or more folding modules (31, 32, 33) being independently operated to carry out different wrapping styles of the wrapping material (101); by positioning at least a folding module (31, 32, 33), fit to be connected to one of the seats (45, 46, 47), it can be set a predefined transfer orientation of said wrapped product (100) towards the outlet group (7).
- 2) Machine according to claim 1 characterized in that the first folding module (31) includes first folder means (40) mobile along a direction tangential with respect to the wrapping head (2) and fit for folding a lower border of the wrapping material portion (101) with double twist wrapping style.
- 3) Machine according to claim 1 characterized in that the first folding module (31) includes two seconds folder means (41) facing each other and oscillating along direction tangential with respect to the wrapping head (2), fit for folding side borders of the wrapping material portion (101) with envelope portfolio wrapping style.
- 4) Machine according to claim 1 characterized in that the second folding module (32) includes folder means third (42) and forth (43) mobile and fit for carrying out orthogonal and opposed folds of borders of the wrapping material portion (101) with envelope portfolio or fancy or bunch wrapping style.

- 5) Machine according to claim 1 characterized in that the third folding module (33) includes a couple of closing fingers (44) for closing the wrapping material (101) according to a double twist wrapper style.
- 5 6) Machine according to claim 1 characterized in that includes first fixed folder means (80) interposed at least between the elevator group (5) and the wrapping head (2) for folding borders of the wrapping material (101) while the elevator group (5) moves the product (100).
- 10 7) Machine according to claim 1 characterized in that includes second fixed folder means (81) positioned around the wrapping head (2) for folding borders of wrapping material (101) when the wrapping head (2) moves the respective product (100).
- 15 8) Machine according to claim 1 characterized in that the first seat (45) is approximately adjacent to the third folding module (32); the second seat (46) is in a position nearly symmetrical to the first seat (45) with respect to vertical plan passing through the rotation axis of wrapping head (2); the third seat (47) is interposed between the seats first (45) and second (46) and approximately aligned to the vertical plan passing through the rotation axis of wrapping head (2).
- 20 9) Machine according to claim 1 characterized in that the third folding station (33) is connected to the first seat (45) and the outlet group (7) of product includes removal means (35), fit to pick each product (100) wrapped by the wrapping head (2) and to transfer it to transport means (36) for orderly moving outwards the products (100), according to a moving direction parallel to the moving direction of the wrapping material (101) in the unwinding and cutting group (6).
- 25 10) Machine according to claim 9 characterized in that the transport means (36) extend starting from the removal means (35) in concordant or opposite direction with respect to the entry direction of products (100) in the feeding group (10).
- 30 11) Machine according to claim 1 characterized in that the third folding station (33) is connected to the second seat (46) or to the third seat (47) and the outlet group (7) includes chute means (38) for the bulk exit of products (100).

12) Machine according to claim 1 characterized in that the feeding group (10) of product (100) includes:

- a first belt means (13), having continuous advance motion, which supports and moves a plurality of products (100), aligned and arranged in a single line at mutual contact;
- 5 - a second belt means (14) aligned and downstream the first belt means (13), having an alternate advance motion and associated to holding means (15) of the product (100);
- a positioning wheel (9) rotating, facing the second belt means (14) downstream the holding means (15) and having angularly equidistant a plurality of pliers means (11) for gripping the product (100);

10 the second belt means (14) moves the products (100), reciprocally spaced, from a picking condition (A), in which the second belt means (14) receives the product (100) from the first belt means (13), through moving conditions (M), in which the holding means (15) keep each product (100) fixed to the second belt means (14), to a transfer condition (T), in which the second belt means (14) is motionless and the product (100), not constrained thereto anymore, is grasped by a pliers (11) of the positioning wheel (9), which moves the product (100) with circular motion, from the transfer condition (T) to a release condition (R) in which the wheel (9) is motionless and pliers (11) is opened for transferring the product (100) to the elevator group (5).

20 13) Machine according to claim 12 characterized in that includes a third belt means (16) aligned to the first belt means (13) and positioned upstream thereto having a continuous advance motion.

25 14) Machine according to claim 13 characterized in that the first belt means (13) has translation speed lower than the speed of third belt means (16) and greater than the average translation speed of second belt means (14).

30 15) Machine according to claim 12 characterized in that the holding means (15) includes at least an air suction means (17) connected through duct means (19) to at least an opening (18) of second belt means (14), in order to hold by suction each product (100) supported by the second belt means (14).

16) Machine according to claim 15 characterized in that the suction means (17) consists in a vacuum pump or a suction fan.

- 17) Machine according to claim 15 characterized in that the opening (18) includes a plurality of through holes carried out on the second belt means (14).
- 18) Machine according to claim 15 characterized in that the second belt means (14) consists of a couple of conveyor belts (22) parallel and transversally spaced apart by a longitudinal slot which realizes an opening (18) at least.
- 19) Machine according to claim 15 characterized in that the duct means (19) include a suction mouth (23) having an elongated shape and in flow communication with the opening (18).
- 20) Machine according to claim 19 characterized in that the duct means (19) include at least a inner duct having divergent shape starting from the suction mouth (23) up to connection with the suction means (17).
- 21) Machine according to claim 12 characterized in that the feeding group (10) includes at least sensor means first (20) and second (25), optical or inductive or capacitive type, fit for sensing the presence of products (100) respectively in correspondence of the first belt means (13) and of the second belt means (14).
- 22) Machine according to claim 12 characterized in that the second belt means (14) is rotatably powered by an electric motor (21) of brushless type, controlled in position, speed and acceleration.
- 23) Machine according to claim 12 and 13 characterized in that that the belt means, first (13) and third (16), are rotatably powered by at least a respective ratio-motor (24).
- 24) Machine according to claim 12 characterized in that the positioning wheel (9) includes at least four pliers means (11) mutually positioned at 90° and fixed to the wheel (9) with an arrangement almost tangential to a circumference inscribed in the positioning wheel (9).
- 25) Machine according to claim 12 characterized in that the positioning wheel (9) includes a first column (61) fixed to the machine (1) and rotatably supporting a second column (62) and a third column (63), coaxial thereto and independently rotating on a vertical axis.
- 26) Machine according to claims 24 and 25 characterized in that each pliers means (11) is fixed,

through a support plate (68), to the third column (63) and includes a couple of mobile tines (12), symmetrically rotating between a closing condition (C), in which said tines (12) are at the minimum mutual distance for gripping a product (100), to an opening condition (D), in which they are at the maximum mutual distance for releasing said product (100).

5

27) Machine according to claim 26 characterized in that each pliers means (11) includes transmission means (65) connected to control means (64) of the second column (62), these last ones being fit to open and close the mobile tines (12) of each pliers means (11), through the rotation of said second column (62).

10

28) Machine according to claim 26 characterized in that each transmission means (65) includes at least a pivot (67), slidably supported by third column (63), connected to the mobile tines (12) of the respective pliers means (11) through a pinion-rack connection, and slidably engaged by sliding rolls (66) to a cam profile of control means (64).

15

29) Machine according to claim 1 characterized in that the elevator group (5) includes articulated quadrilaterals (51, 52) connected to respective powered cams and fit for moving at least a counter-elevator means (50) and an elevator means (53).

20

30) Machine according to claim 29 characterized in that the elevator means (53) includes at least two side rests (59) for supporting the wrapping material portion (101) during the raising of product (100).

25

31) Machine according to claim 1 characterized in that the feeding group (10) of the product (100) includes:

- a storage belt (71), having an alternate advance motion, for moving aligned products (100);
- pusher means (72) for transferring each product (100) from the belt (71) to a feeding disk (73), having a plurality of first slots (74) for housing products (100) and rotating on a vertical axis for transporting these last ones to the elevator group (5).

30

32) Machine according to claim 1 characterized in that the feeding group (10) includes a storage hopper (75) of product (100) which feeds a centrifugal filling disk (76), having a plurality of second slots (60) and rotating on a vertical axis for transporting each product (100) to the elevator group (5).

35

- 33) Machine according to claim 1 characterized in that the feeding group (10) includes a belt (77) provided with counter-dies (78) for accommodating respective products (100) and for transferring said products to the elevator group (5).
- 5 34) Machine according to claims 31 and 32 characterized in that the feeding group (10) is of combined type and includes at least a storage belt (71) with pusher means (72) and a feeding disk (73), and a hopper (75) with centrifugal filling disk (76).
- 10 35) Machine according to any of the preceding claims characterized in that is totally controlled by electronic calculation and control means fit to control the phase relations at least among the feeding group (10), the elevator group (5), the unwinding and cutting group (6), the wrapping head (2), the folding group (3) and the outlet group (7).

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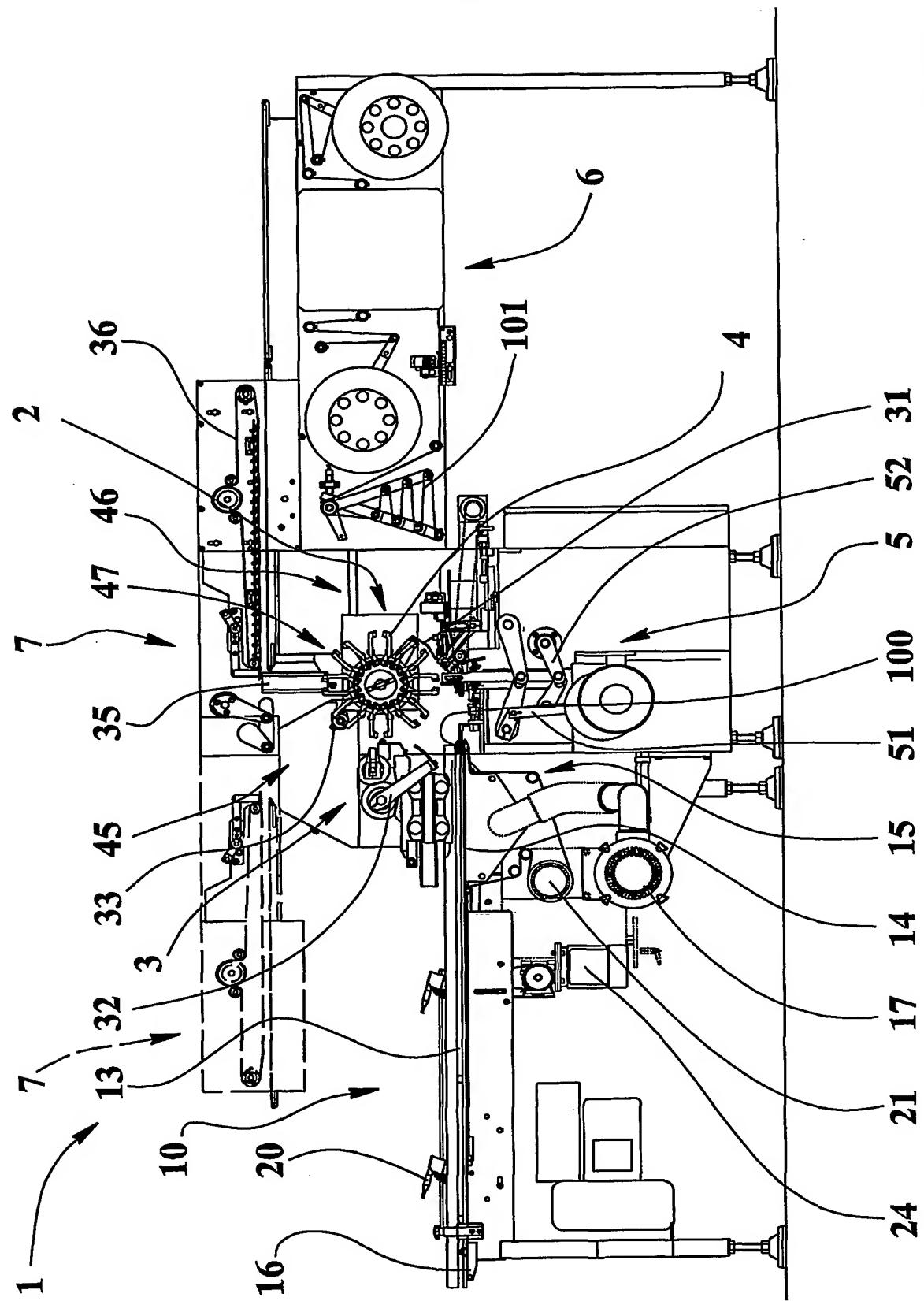
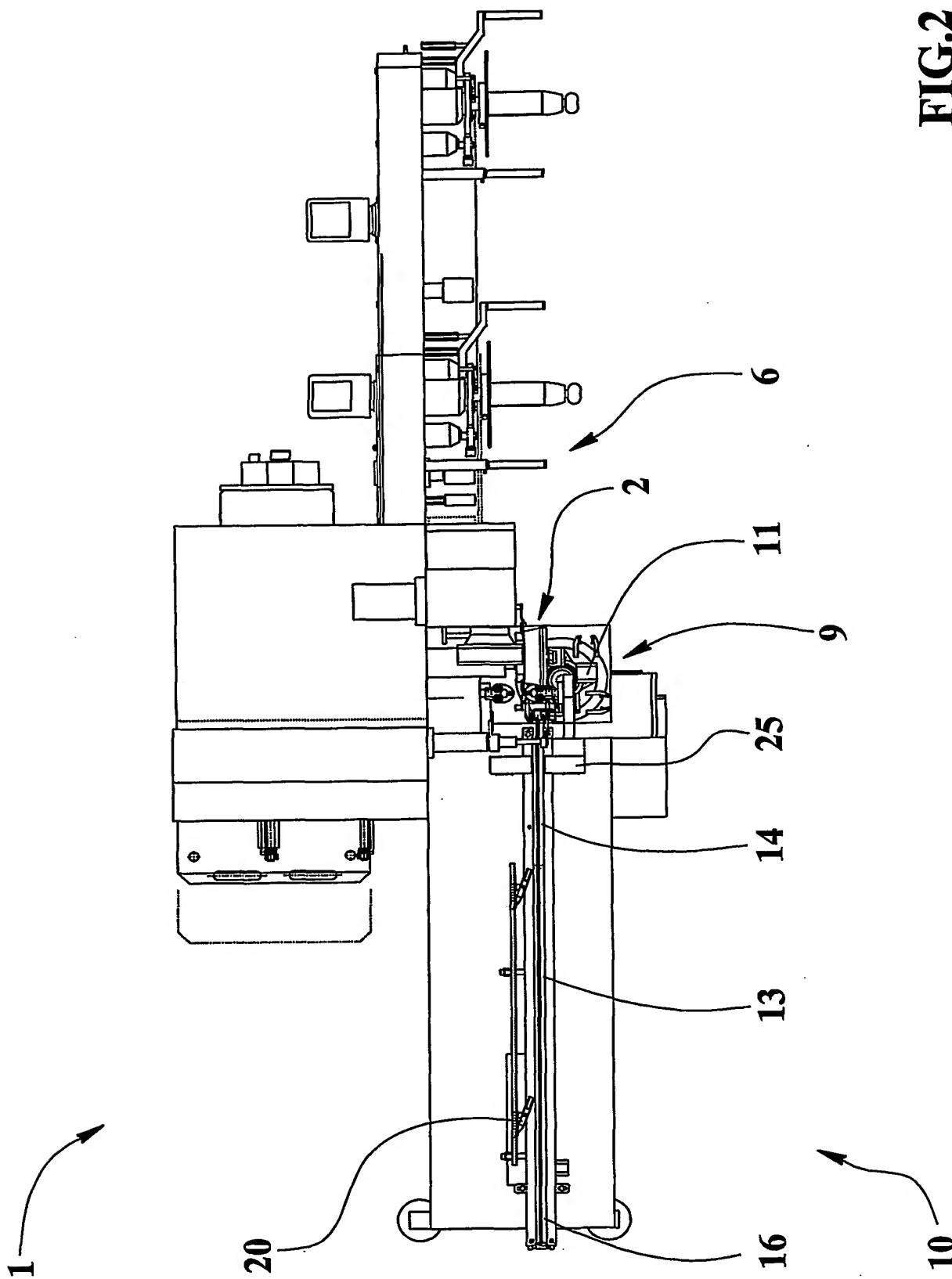


FIG. 1

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FIG.2

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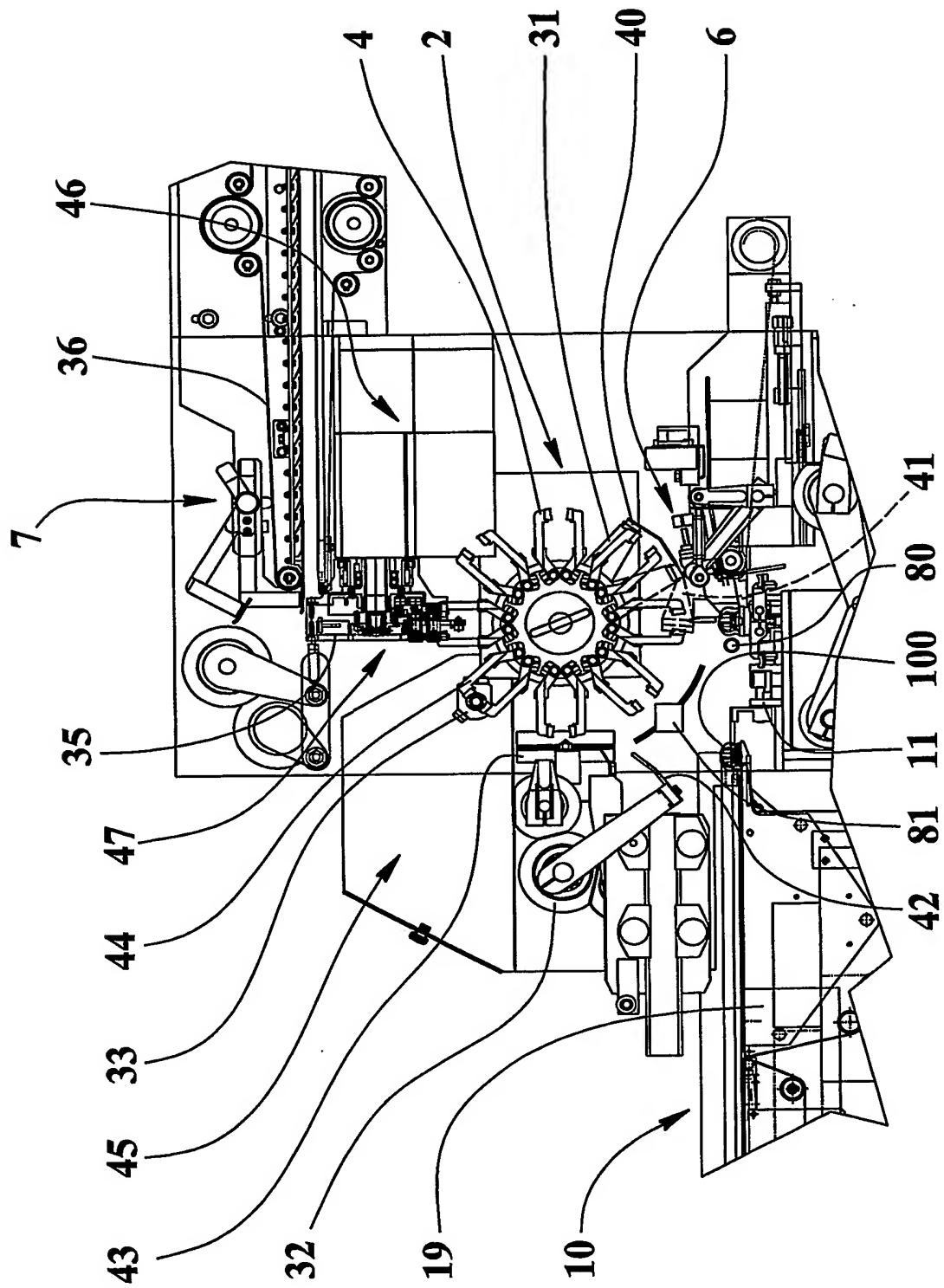


FIG.3

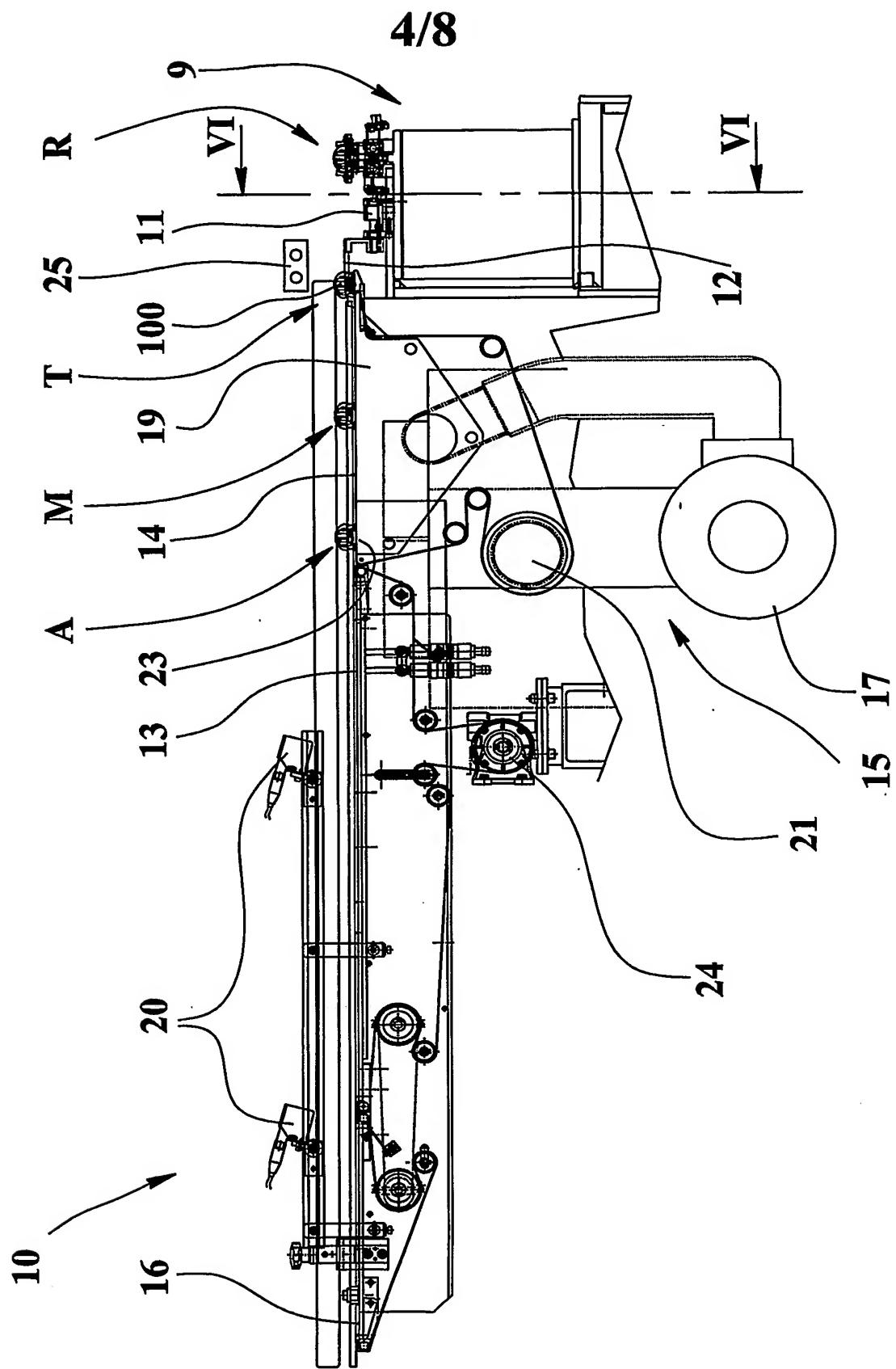


FIG.4

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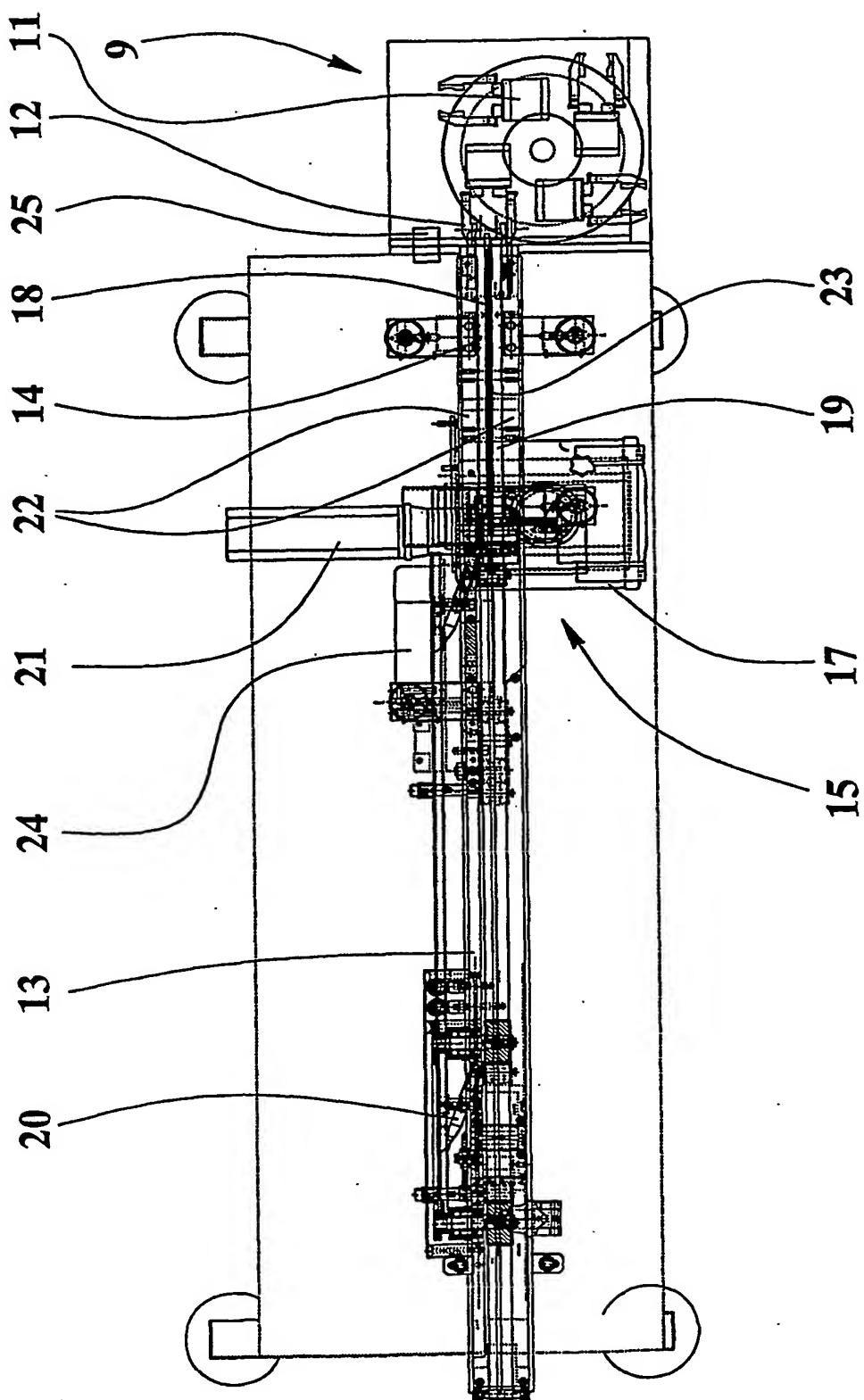


FIG.5

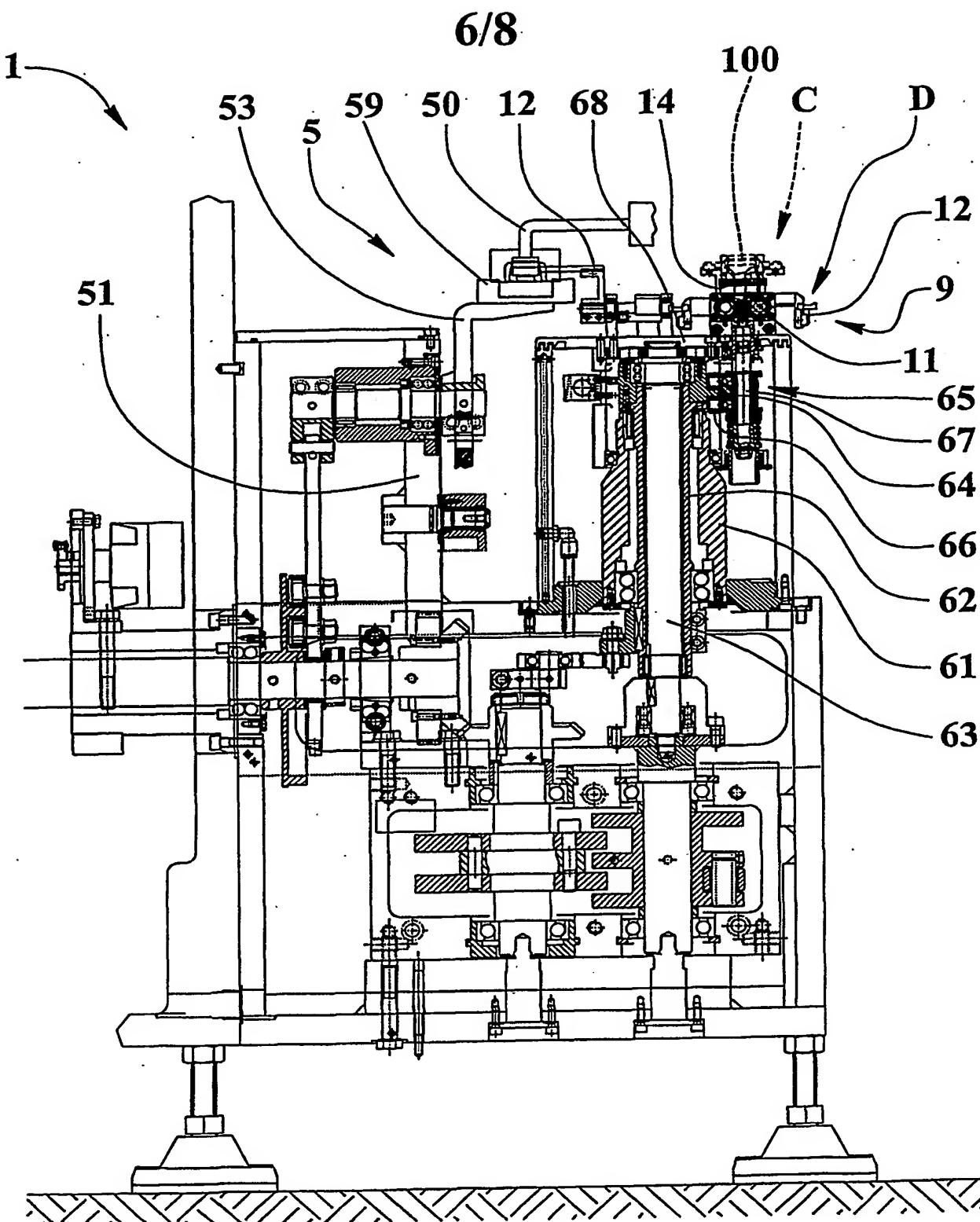
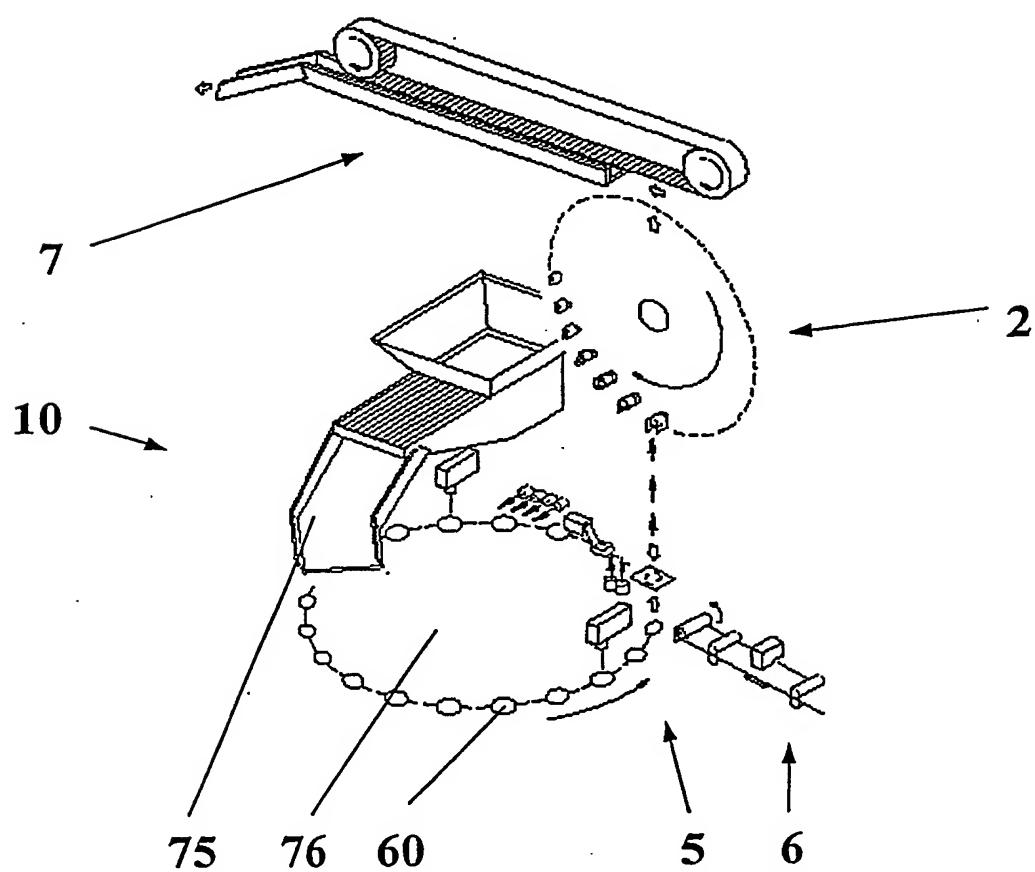
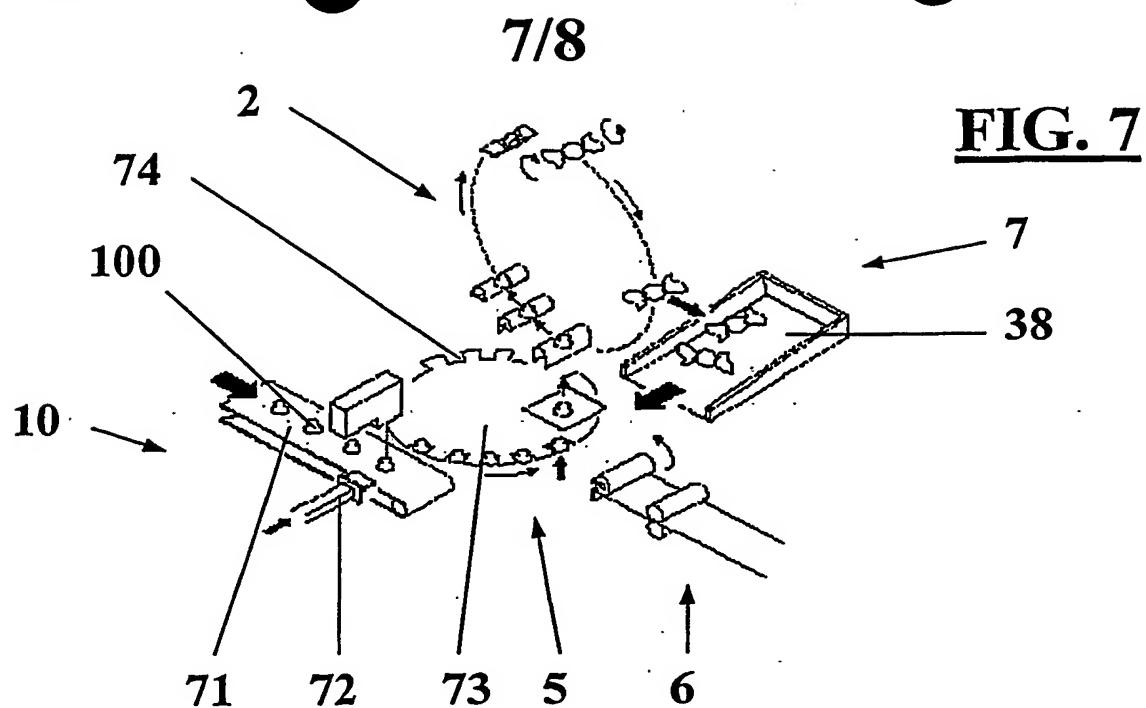
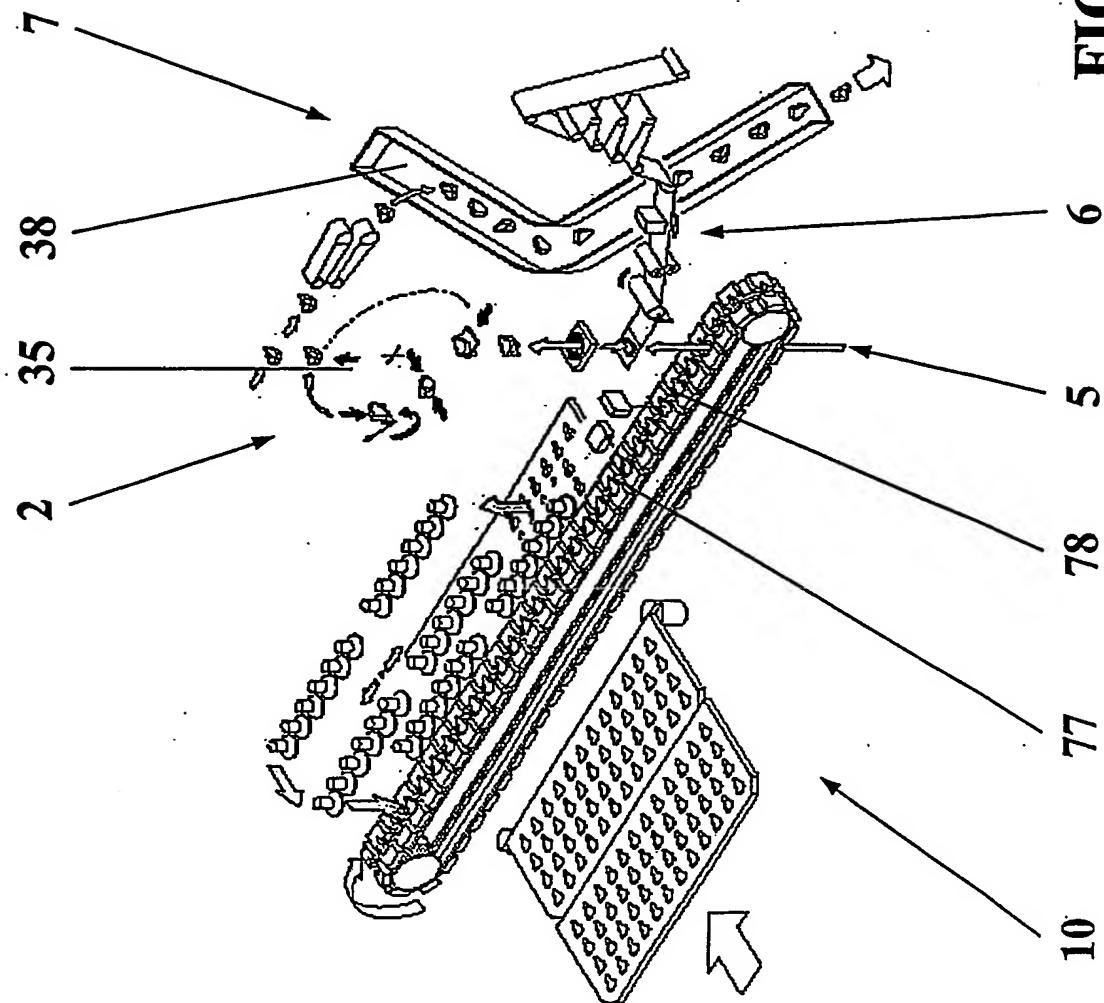


FIG.6



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FIG. 9

INTERNATIONAL SEARCH REPORT

International Application No
PCT/IB 00/01203

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 B65B11/28 B65B59/04

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B65B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 733 548 A (NUOVA FIMA IMBALLAGGI) 25 September 1996 (1996-09-25) column 1, line 3 -column 2, line 14 column 5, line 4 -column 8, line 40 column 10, line 52 -column 15, line 47 column 17, line 14 - line 43; figures 1-36 ---	1-7, 29, 30, 35
A	US 3 899 865 A (REVAZ LEON) 19 August 1975 (1975-08-19) column 2, line 4 -column 5, line 8; figures 1-3 ---	1-11, 29-35
A	EP 0 769 453 A (AZIONARIA COSTRUZIONI) 23 April 1997 (1997-04-23) column 5, line 16 - line 46; figures 1,5 ---	1, 12 -/-

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

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Date of the actual completion of the international search

Date of mailing of the International search report

20 June 2003

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INTERNATIONAL SEARCH REPORT

International Application No
PCT/IB 00/1203

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

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